

Date: Monday, 25/05/2009 11:22:35 AM
 User: Melanie Fauteux

Process Sheet

Customer :	CU-DAR001 Dart Helicopters Services	Drawing Name :	GASKET
Job Number :	48185		
Estimate Number :	13906		
P.O. Number :		Part Number :	D38467
This Issue :	25/05/2009	S.O. No. :	
Prsht Rev. :	NC	Drawing Number :	D3846 PREL
First Issue :	//	Project Number :	N/A
Previous Run :		Drawing Revision :	PREL
	Type :	Material :	
	SMALL /MED FAB	Due Date :	01/06/2009
Written By :		Qty:	4
Checked & Approved By :	<u>MF 09-05-25</u>	Um:	Each
Comment :	Est Rev:A 09.04.30 new issue EC verified by:DD		

Additional Product

PRELIMINARY ISSUE

Job Number:



Seq. #:	Machine Or Operation:	Description :
---------	-----------------------	---------------

1.0	MNEO60S063	NEOPRENE SHEET 0.063
-----	------------	----------------------



Comment: Qty.: 1.3608 sf(s)/Unit Total : 5.4432 sf(s)

NEOPRENE SHEET 0.063

batch: 111469

B 9-5-06

2.0	WATER JET	FLOW WATER JET
-----	-----------	----------------



Comment: FLOW WATER JET

1-Cut as per Dwg D3846

Dwg Rev: PREProg Rev: Lim

B 9-5-06



2-Deburr if necessary

3.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
-----	-----	--



B 9-5-06

Comment: INSPECT PARTS AS THEY COME OFF MACHINE

4.0	QC8	SECOND CHECK
-----	-----	--------------



Comment: SECOND CHECK

09-06-03 **ENGINEERING APPROVAL**

5.0	PACKAGING 1	PACKAGING RESOURCE #1
-----	-------------	-----------------------



Comment: PACKAGING RESOURCE #1

Identify with Dart part # using yellow paint marker and Stock

Location: _____

1

prototype table

MF 09-06-22

Daft Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Monday, 25/05/2009 11:22:35 AM
User: Melanie Fauteux

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: GASKET

Job Number: 48185

Part Number: D38467

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

Job Completion



POSITIVE RECALL

EFFECTIVE 09.05.25 AUTH MF

RELEASED _____ DATE _____

MF 09-06-22

FOR ENG USE
ONLY. SCRAP
REMAINDER OF
BATCH

09.05.02

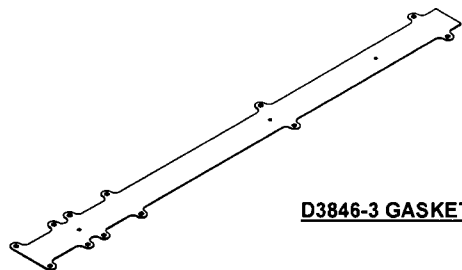
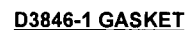
Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

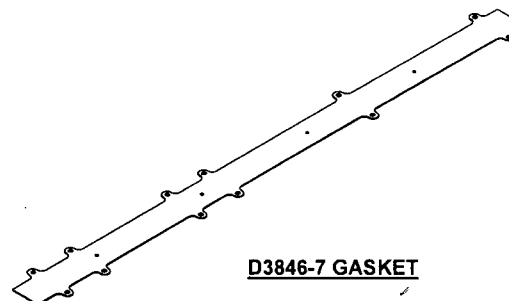
Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

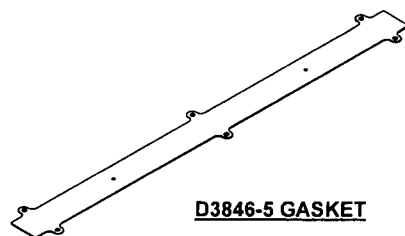
NOTE: Date & initial all entries



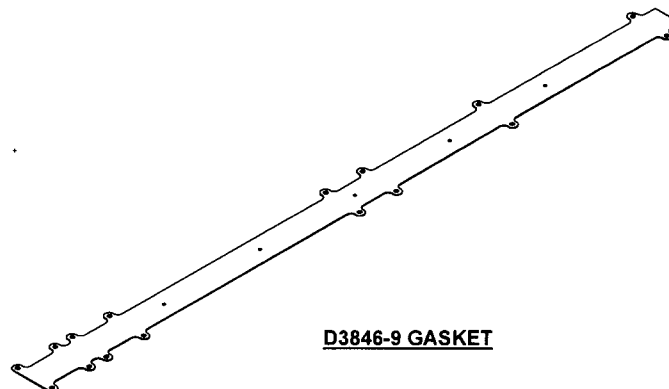
D3846-3 GASKET



D3846-7 GASKET



D3846-5 GASKET



D3846-9 GASKET



D3846-11 GASKET

NOTES:

NOTES:
1) MATERIAL: BLACK NEOPRENE SHEET, 0.063 THICK, 60 DUROMETER
(REF. DART SPEC. M-NEO60-S.063)

2) FINISH: NONE

3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED

4) UNITS: INCHES UNLESS OTHERWISE NOTED

5) BREAK SHARP EDGES: N/A

6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3846-X" USING YELLOW PAINT MARKER

7) WEIGHT:

7) WEIGHT:

D3846-1	= 0.03 lbs
D3846-3	= 0.25 lbs
D3846-5	= 0.20 lbs
D3846-7	= 0.27 lbs
D3846-9	= 0.35 lbs
D3846-11	= 0.04 lbs

D3846-3 = 0.25 lbs

D3846-5 = 0.20 lbs





D3846-7 = 0.27 lbs

D3846-9 = 0.35 lbs

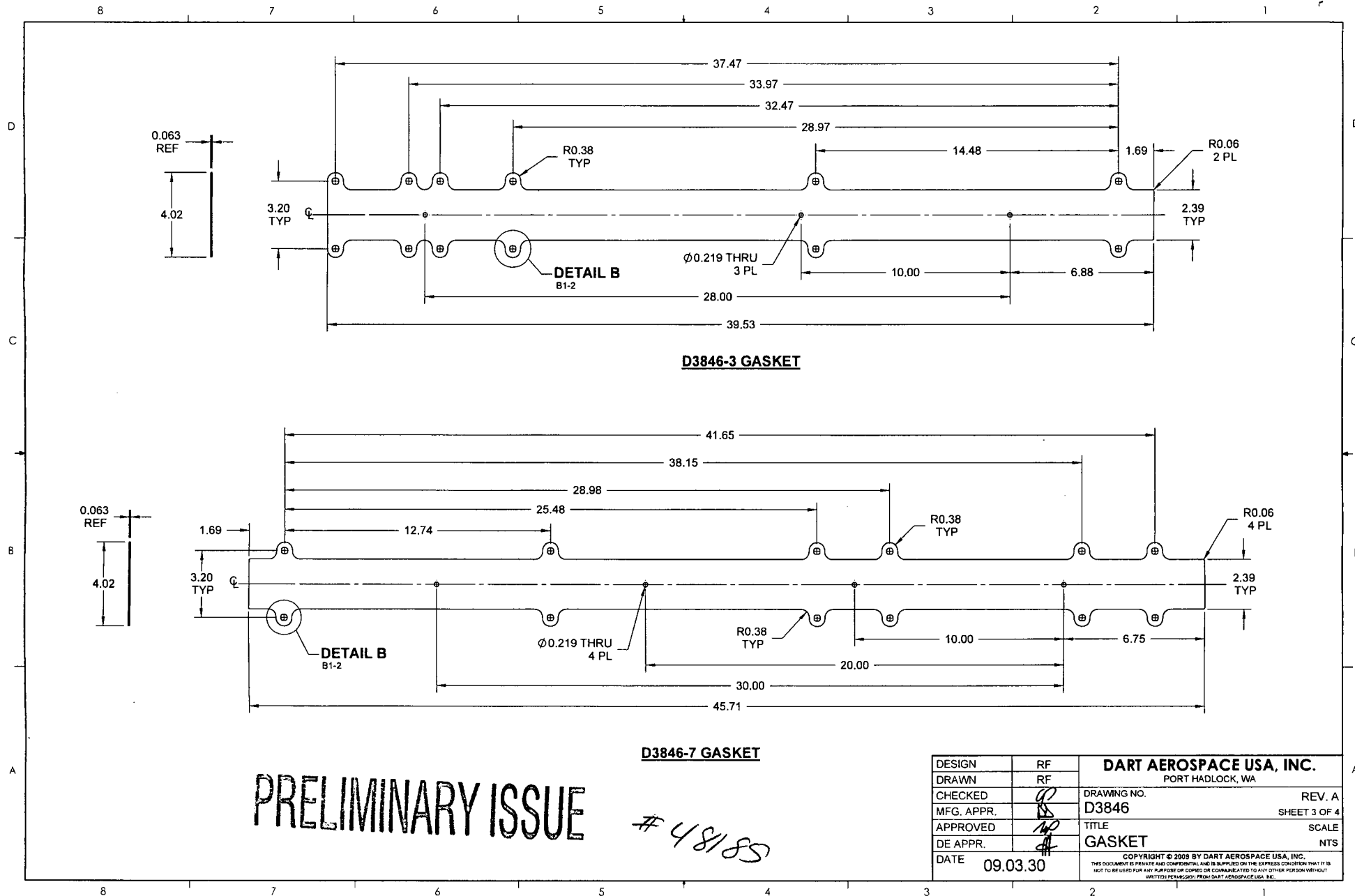
D3846-11 = 0.04 lb:

PRELIMINARY ISSUE

48/8.5

A	NEW ISSUE	RF	09.03.30
REV.	DESCRIPTION		BY DATE
DESIGN	RF	DART AEROSPACE USA, INC.	
DRAWN	RF	PORT HADLOCK, WA	
CHECKED		DRAWING NO.	REV. A
MFG. APPR.		D3846	SHEET 1 OF 1
APPROVED		TITLE	SCALE
DE APPR.		GASKET	NTS
DATE	09.03.30	COPYRIGHT © 2009 BY DART AEROSPACE USA, INC. THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL, AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT THE WRITTEN PERMISSION OF DART AEROSPACE USA, INC.	

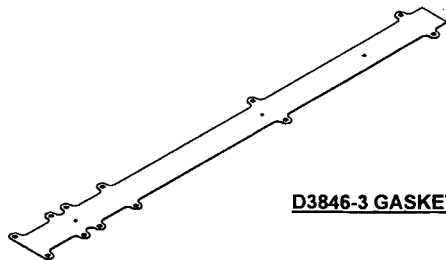
COPYRIGHT © 2009 BY DART AEROSPACE USA, INC.
THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL, AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT
NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT
WRITTEN PERMISSION FROM DART AEROSPACE USA, INC.



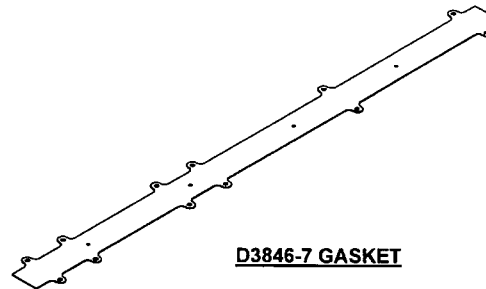
8 7 6 5 4 3 2 1



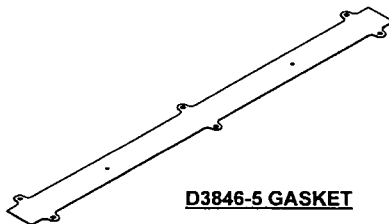
D3846-1 GASKET



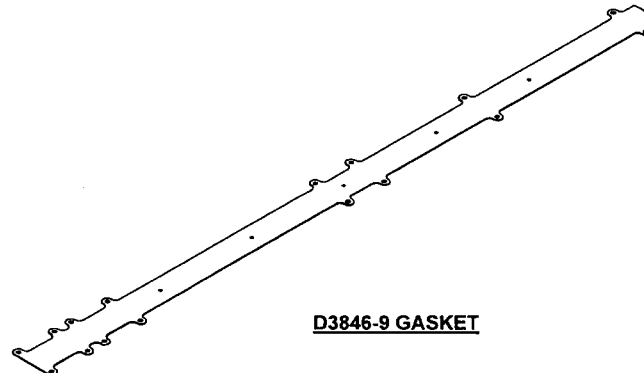
D3846-3 GASKET



D3846-7 GASKET



D3846-5 GASKET



D3846-9 GASKET



D3846-11 GASKET

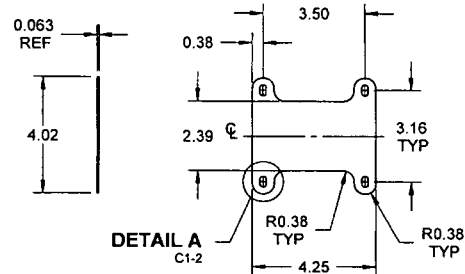
48185

RELEASED
9/15/11

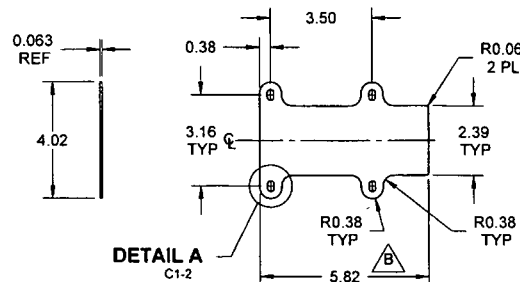
NOTES:

- 1) MATERIAL: BLACK NEOPRENE SHEET, 0.063 THICK, 60 DUROMETER
(REF. DART SPEC. M-NEO60-S.063)
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: N/A
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3846-X" USING YELLOW PAINT MARKER
- 7) WEIGHT:
 - D3846-1 = 0.03 lbs
 - D3846-3 = 0.25 lbs
 - D3846-5 = 0.20 lbs
 - D3846-7 = 0.26 lbs
 - D3846-9 = 0.35 lbs
 - D3846-11 = 0.04 lbs

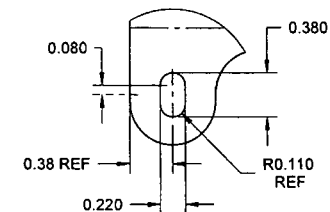
B	5.82 WAS 6.25 (ZN C4-2); 45.28 WAS 45.71 (ZN A4-3); 6.32 WAS 6.75 (ZN B2-3)	RF	09.06.30
A	NEW ISSUE	RF	09.03.30
REV.	DESCRIPTION	BY	DATE
DESIGN	RF	DART AEROSPACE USA, INC. PORT HADLOCK, WA	
DRAWN	RF		
CHECKED	RF	DRAWING NO.	REV. B
MFG. APPR.	RF	D3846	SHEET 1 OF 4
APPROVED	RF	TITLE	SCALE
DE APPR.	RF	GASKET	NTS
DATE	09.06.30	COPYRIGHT © 2009 BY DART AEROSPACE USA, INC. THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSES OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE USA, INC.	



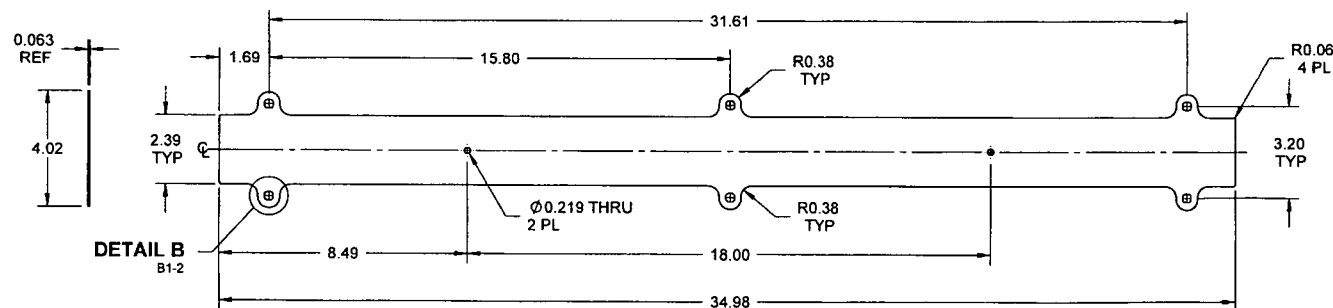
D3846-1 GASKET



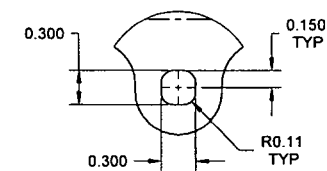
D3846-11 GASKET



DETAIL A CS-2
TYP, SCALE 4X C7-2



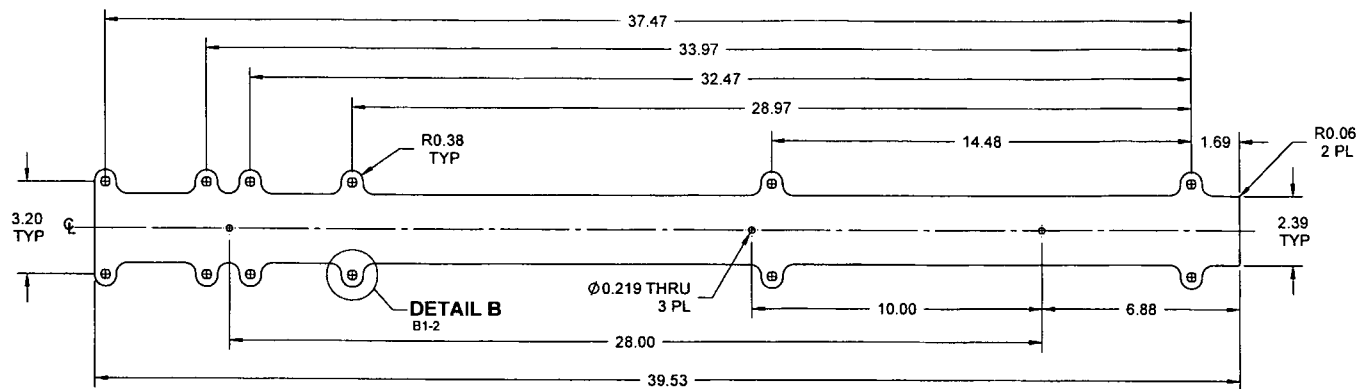
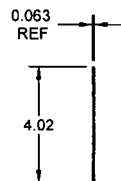
D3846-5 GASKET



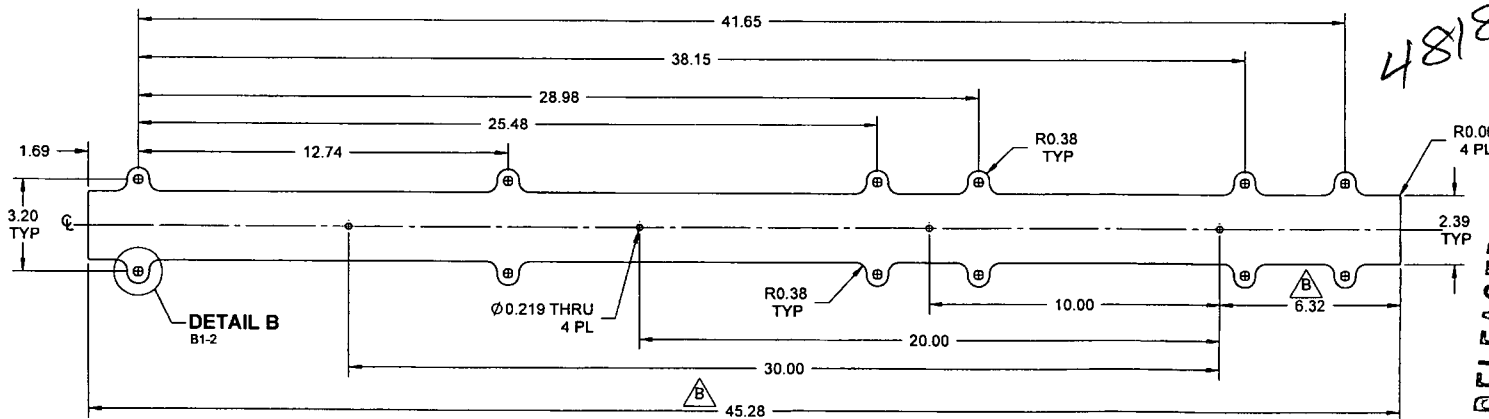
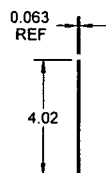
DETAIL B A7-2
TYP, SCALE 4X C5-3
B7-3
C5-4

RELEASED
CAB/15/14

DESIGN	RF	DART AEROSPACE USA, INC.	
DRAWN	RF	PORT HADLOCK, WA	
CHECKED	PD	DRAWING NO.	REV. B
MFG. APPR.	PD	D3846	SHEET 2 OF 4
APPROVED	APR	TITLE	SCALE
DE APPR.	APR	GASKET	NTS
DATE	09.06.30	<small> COPYRIGHT © 2009 BY DART AEROSPACE USA, INC. THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE USA, INC. </small>	



D3846-3 GASKET



D3846-7 GASKET

DESIGN	RF	DART AEROSPACE USA, INC.	
DRAWN	RF	PORT HADLOCK, WA	
CHECKED	RF	DRAWING NO.	REV. B
MFG. APPR.	RF	D3846	SHEET 3 OF 4
APPROVED	RF	TITLE	SCALE
DE APPR.	RF	GASKET	NTS
DATE	09.06.30	COPYRIGHT © 2009 BY DART AEROSPACE USA, INC.	
THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSES OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE USA, INC.			

RELEASED
10/27/15

0.063
REF

4.02

R0.06
2 PL

2.39
TYP

1.69

11.50

9.00

18.00

27.00

36.00

60.00

DETAIL B

B1-2

R0.38
TYP

R0.38
TYP

Ø0.219 THRU
5 PL

3.20
TYP

D3846-9 GASKET

48185

RELEASED
07/15/10

DESIGN	RF	DART AEROSPACE USA, INC. PORT HADLOCK, WA	
DRAWN	RF		
CHECKED	<i>[Signature]</i>	DRAWING NO.	REV. B
MFG APPR.	<i>[Signature]</i>	D3846	SHEET 4 OF 4
APPROVED	<i>[Signature]</i>	TITLE	SCALE
DE APPR.	<i>[Signature]</i>	GASKET	NTS
DATE	09.06.30	<small>COPYRIGHT © 2009 BY DART AEROSPACE USA, INC. THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE USA, INC.</small>	